

Date: Tuesday, 19/08/2008 4:03:46 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DECK PLATE,FWD ,350 LITTER KIT
Job Number	: 41423		
Estimate Number	: 11104		
P.O. Number	:	Part Number	: D2364
This Issue	: 19/08/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2364 REV.F
First Issue	: / /	Project Number	: N/A
Previous Run	: 39239	Drawing Revision	: F
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 08/09/2008
Checked & Approved By	: <u>JUL 08.8.9</u>	Qty:	6
Comment	: EST. REV. E 00.06.26 Removed P/O for powder coat EC Est Rev:F Now On Waterjet 06-07-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 0.6792 sf(s)/Unit Total : 4.0755 sf(s)
 2024-T3 .063 Aluminum sheet
 (M2024T3S063)
 Batch: 108415 IB 8-8-22

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2364
 Dwg Rev: F
 Prog Rev: F

IB 8-8-22

⑦

2-Deburr if necessary IB 8-8-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEIB 8-8-22

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECKS 08/09/23 ⑦

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1- counter sink holes as per dwg D2364

CP 08/09/23 ⑦

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:03:46 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE,FWD ,350 LITTER KIT

Job Number: 41423

Part Number: D2364

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- deburr if necessary

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/09/23 (X7)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-l 08/09/26

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:10 OF
320
8:40

m-l 08/09/27

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P 8/9/29

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 186

P 8/9/29 (7)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30

Job Completion



MF 08-09-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41423
Description: Litter Deck Plate Kit (350)		Part Number: D2364
Inspection Dwg: D2364	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.631	*			
Ø0.171	+0.005/-0.000	0.172	*			
0.354	+/-0.010	0.356	*			
11.242	+/-0.010	11.247	*			
3.031	+/-0.010	3.035	*			
1.903	+/-0.010	1.905	*			
1.128	+/-0.010	1.129	*			
0.354	+/-0.010	0.357	*			
1.340	+/-0.005	1.347	*			
2.326	+/-0.010	2.329	*			
3.312	+/-0.010	3.317	*			
4.298	+/-0.010	4.298	*			
5.284	+/-0.010	5.284	*			
6.151	+/-0.010	6.155	*			
6.270	+/-0.010	6.273	*			
0.354	+/-0.010	0.356	*			
3.031	+/-0.010	3.035	*			
Ø0.656	+0.005/-0.000	0.657	*			
5.003	+/-0.010	5.003	*			
4.605	+/-0.010	4.606	*			
1.776	+/-0.010	1.778	*			
0.980	+/-0.010	0.983	*			
4.487	+/-0.010	4.488	*			
7.192	+/-0.010	7.195	*			
7.567	+/-0.010	7.567	*			
7.942	+/-0.010	7.950	*			
Ø0.191	+0.005/-0.000	0.193	*			
Ø0.197	+0.005/-0.000	0.198	*			
11.145	+/-0.010	11.145	*			
12.181	+/-0.010	12.181	*			
11.378	+/-0.010	11.378	*			
11.776	+/-0.010	11.776	*			
12.173	+/-0.010	12.173	*			
4.690	+/-0.010	4.695	*			
0.250	+0.005/-0.000	0.251	*			
3.141	+/-0.010	3.149	*			
0.171	+0.005/-0.000	0.173	*			

Measured by: JB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 8-8-26	Date: 08/06/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD [Signature]	[Signature]



RELEASED
99/06/22 KG

MATERIAL: 2024-T3 (90-A-250/5) 0.063-0.071 THICK
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**UNCONTROLLED COPY
SUBJECT TO AMENDMENT**

WITHOUT NOTICE

WORK ORDER
4742
NO